

Claims

1. Method for welding metal sheets (2, 3) to form tailored blanks, characterized in that the edge line of both sheets is detected in the welding machine, the edge line of one of the sheets is identified as the dominant edge line and the other edge (2', T) is reworked to match it to the dominant edge, and in that the sheets are then welded.
2. Apparatus according to Claim 1, characterized in that a sheet is discarded before reworking takes place, if the deviation of its edge from the dominant edge exceeds a predetermined amount.
3. Apparatus according to Claim 1 or Claim 2, characterized in that the edges are sensed by means of at least one sensor (6, 7) to determine the edge line.
4. Apparatus according to Claims 1 to 3, characterized in that the edge requiring reworking is machined by pressing.
5. Apparatus according to any one of Claims 1 to 4, characterized in that guidance of the welding beam is governed by, or is in part governed by, the detected dominant edge line.
6. Apparatus for welding metal sheets (2, 3) to form tailored blanks, characterized by at least one detection device (6, 7, 9) for detecting the edge line of the sheet edges (2', 3') to be welded, a control unit (9) for identifying one of the detected edges as the dominant edge and for transmitting control signals to at least one machining unit (10) arranged in the apparatus for machining the non-dominant edge.
7. Apparatus according to Claim 6, characterized in that the control unit is configured for the transmission of control signals to a discard unit whereby one of the sheets can be discarded from the apparatus before welding takes place.

8. Apparatus according to Claim 6 or Claim 7, characterized in that the detection device comprises at least one sensor (6, 7).

9. Apparatus according to any one of Claims 6 to 8, characterized in that the machining device comprises at least one pressing tool, in particular a roller (110).

10. Apparatus according to any one of Claims 6 to 9, characterized in that the control unit (9) forms the welding beam control or is configured for transmission of data to such a control.